

Work Order ID 65671

January 21, 2011 1:50:24 PM



Page 1

Item ID: D4276-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Beam

Start Date: 1/21/11 Start Qty: 2.00



Cust Item ID:

Required Date: 2/01/11 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr:

Revision Nbr:

D4276

A

100

0.00



BAND SAW

0.00

Bandsaw

Memo

Jeaspa Bandsaw

Cut Blank to 36.630"

Batch: 107221

B.A 11/01/31

2

0

110

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

1-Machine per folio FB007

DWG REV: A

FOLIO REV: AA

B.A 11/01/31

2

0

2- deburr rough edges

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		B.A 11/01/31		2	0		
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		amk 11/02/01		2	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				2		BL 11-02-2:	

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Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

145

White Gloss(Ref:4.3.5.1) per OSI005 4.3 Alum

0.00



Powdercoat

Powder Coating

M115451

START: 7:30
OVERT: 3:20
FINISH: 3:00
MEMO MASK AS PER DWG

2

BL 11-02-3.

150

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

=> JH 11/02/03

2 d

180

Identify as per dwg & Stock Location:

0.00



Packaging

Packaging

Memo

0.00

196

64124 (2)

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11-02-04

MF

11-02-04

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Picklist Print

January 21, 2011 1:50:23 PM

Page 1

Work Order ID: 65671

Parent Item: D4276-1

Parent Item Name: Aft Beam



Start Date: 1/21/11

Required Date: 2/01/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-11-17 JLM VERIFIED BY:DD IPP rev:B
10.12.02 AS PER DWG REV.A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased	No			100	f	53.2995	3.052	6.425263			



6061-T6 Bar 1.00 x 4.00



Location

Loc Qty

Loc Code

MAT03

53.2995

✓107221

45.2937

114352

8.0058

6.4252 ft B.A 11/01/31

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DART AEROSPACE LTD		Work Order: 65671
Description: AFT BEAM		Part Number: D4276-1
Inspection Dwg: D4276 Rev: A		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

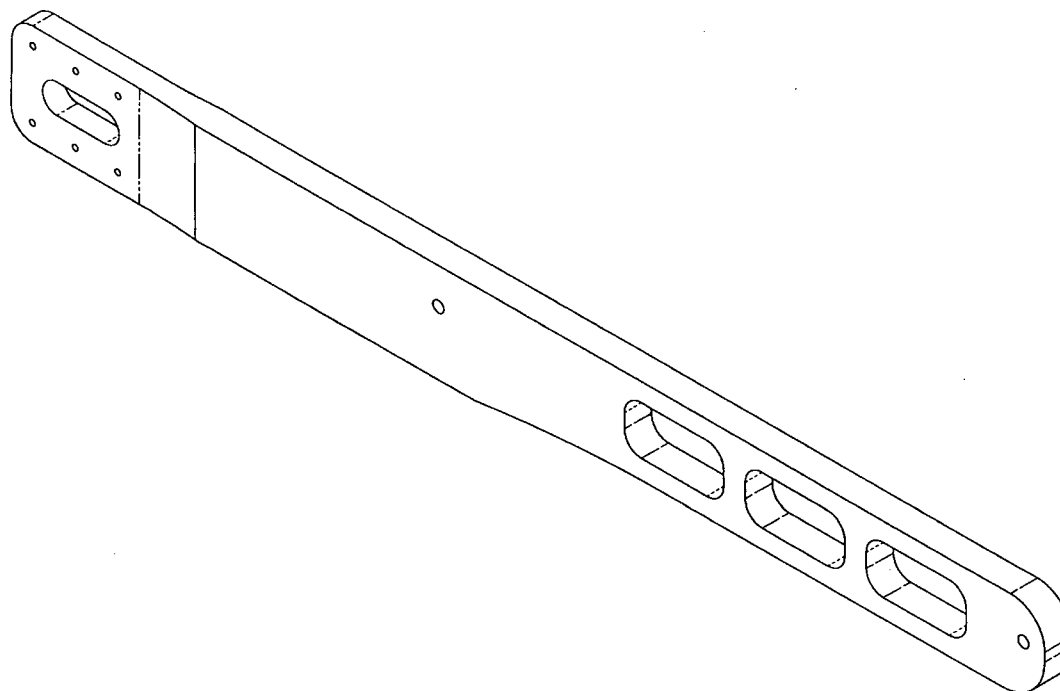
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/- .030	3.503	✓		Vern	GA-01
R0.75	+/- .030	R0.750	✓		R-6	ref.
14.380	+/- .010	14.380	✓		Tape	GA-12
φ0.381	+0.000/-0.001	φ0.3809	✓		Mic	GA-03
20.500	+/- .010	20.500	✓		Tape	GA-12
0.75	+/- .030	0.751	✓		Vern	GA-01
1.250	+/- .010	1.252	✓		H-6	31006
3.00	+/- .030	3.003	✓		Vern	GA-01
3.50	+/- .030	3.503	✓		"	"
2.75	+/- .030	2.753	✓		"	"
0.75	+/- .030	0.753	✓		"	"
5.00	+/- .030	5.002	✓		"	"
0.734	+/- .010	0.733	✓		"	"
0.108	+/- .010	0.102	✓		Dial	HAAS2
0.95	+/- .030	0.949	✓		Vern	GA-01
4.50	+/- .030	4.500	✓		"	"
1.10	+/- .030	1.100	✓		"	"
1.25	+/- .030	1.249	✓		"	"
0.75	+/- .030	0.751	✓		H-6	31006
1.500	+/- .010	1.500	✓		Vern	GA-01
3.000	+/- .010	3.000	✓		"	"
φ0.191	+0.005/- .001	φ0.195	✓		"	"
2.300	+/- .010	2.300	✓		"	"

Measured by: B. A
Date: 11/01/31

Audited by: <i>aml</i>
Date: 11/02/01

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4276-1 AFT BEAM

W/O 65671

RELEASE
2010-11-30

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.68 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT.

A		NEW ISSUE		SC	10.11.25
REV.		DESCRIPTION		BY	DATE
DESIGN	SC	DART AEROSPACE LTD			
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA			
CHECKED	#	DRAWING NO.	REV. A		
MFG. APPR.	#	D4276	SHEET 1 OF 2		
APPROVED	#	TITLE	SCALE		
DE APPR.	#	AFT BEAM	NTS		
DATE		10.11.25			
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